

Work Order ID 87205

87205

Page 1

July-11-12 10:10:46 AM

Item ID: D350-604-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Rear Locker Extender

Start Date: 7/16/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/24/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: *W*

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2273

F

D350-604-041

B

100

0.00

100

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile and create labels per PPP D350-604-041

CHG003 for D2273 rev.E (new gelcoat)

CHG004 for D2273 rev.F (new primer)

110

0.00

110

Purchasing

Purchasing

PURCHASING

Memo

Issue P/O: 17579

Description: D350-604-041 Rear locker extender.

Supplier: Delastek.

Certification of Conformity and process sheet from Delastek is required.

4 x 2600-6 Camlock stud - Ship to Delastek B 1233174 x 2600-LW Retaining washers - Ship to Delastek B 121524

SCRAP

*scrap*12-07-3112-07-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 87205***87205***

Page 2

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Start Date: 7/16/12 Start Qty: 1.00

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Cust Item ID:

Required Date: 8/24/12 Req'd Qty: 1.00

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

120

Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs
Packaging

0.00

Memo

0.00

Ensure a copy of Certification of Conformity and process sheet from Delastek is attached.

1X

SP

12-8-16

130

130

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Check hole locations to template. DT 8824 Check process sheet and audit.

DAS
16
12/05/17

7to ->

140

140

Small Fab

Small Fab

Memo

INSTALL DECALS AS PER DWG

0.00

0.00

Dart Aerospace Ltd

W/O: 87205		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

See Pink NCR
12-18-19

Part No: D350-604-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Yes Date: 12/09/18

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/06/17		Parts Revers in not drum R.C. drum	DAS 15 2-83 Q57412 12/06/17	Per as per drum and per Q57004	M 12-09-17		DAS 15 2-83 Q57004 12/06/17	DAS 16 2-83 12/06/17
12/06/17	# 120	Found that the weight of the Rear locker is 14.0 lbs. Drawing is allowing 7.75 lbs.						
		R.C. improperly made.						

NOTE: Date & initial all entries

87205

July-11-12 10:10:46 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 7/16/12 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 8/24/12 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

0.00

160

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-604-041

Location:

PPP Rev:

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July-11-12 10:10:46 AM

Page 1

Work Order ID: 87205

Parent Item: D350-604-041

Parent Item Name: Rear Locker Extender

Start Date: 7/16/12

Required Date: 8/24/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:Q03.12.01ReformatKJ/RF IPP REV:R 12.02.07 AS PER ECN12-
521 DD verf:JLM IPP REV:S 12.04.04 AS PER DWG REV.B DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
2600-6 Camlock Stud		Purchased	No			110	Each	199.0000	4	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST380		199							
				120077		8							
				121556		4							
				122317		42							
				122335		145							
2600-LW Camloc Retaining Washer		Purchased	No			110	Each	319.0000	4	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST380		316							
				121524		116							
				122317		200							
				ST381		1							
				121287		1							
				ST398		2							
				120648		2							
D2268 Decal		Manufactured	No			140	Each	31.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST007		20							
				80010		20							
				ST009		11							
				69592		2							
				78908		9							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July-11-12 10:10:46 AM

Page 2

Work Order ID: 87205

Parent Item: D350-604-041

Start Date: 7/16/12

Required Date: 8/24/12

Parent Item Name: Rear Locker Extender

Start Qty: 1.00

Required Qty: 1.00

D2269 Manufactured No Each 25.0000 1
Decal

Location

Loc Qty

Loc Code

ST007 20
80011 20
ST009 5
78920 5

D350-604-041P Purchased No 110 Each 0.0000 1 1
Rear Locker Extender

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

****Certificate of Conformity****

Customer:

Dart Aerospace

Purchase Order #:

PO17579

Packing Slip #:

Part #:

D350-604-041P

Serial #:

N/A

Description:

Stealth spec 2 ply flange locker

Quantity:

1

Certification:

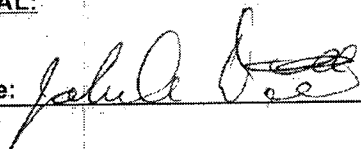
We hereby certify that:

1. The above the listed items were manufactured, repaired and/or inspected in accordance with applicable drawings and/or specifications;
2. All work was accomplished in accordance with the Dart Aerospace Purchase Order;
3. Results of all inspections, chemical or physical tests, as well as other evidence, which shows the acceptability of raw materials, parts and/or assembly components are on file and available for inspection at any time.

Authority:

APPROVAL:

Signature:



Title: President

DATE:

8/15/2012

Sheet1

Stealth Composites Inc.

Process Data Sheet

Date: 8/9/12
 Client: DART
 Job:
 Comments: Stealth spec locker 2 ply flange

Part Name: Stealth spec extended locker
 Part Number: D350-604-041P
 Revision: n/a
 Material: fiberglass/FR polyester resin
 Quantity: 1

Resin: Hetron FR 650 T-20
 Gelcoat: G730AA1100
 Catalyst: Cadox M-50A
 Fiber: 1.5 oz random fiberglass mat

Batch: 0001291211
 Batch: G31
 Batch: 12041F0701

Setup: Operation n/a
 Mold Prep: clean with dry cloth
 Material prep: Cut fiberglass to fit mold
 Mix gelcoat: Catalyze gelcoat @1.5% Cadox
 Apply gelcoat: Spray mixed gelcoat onto mold
 Mix resin: Catalyze resin @1.5% Cadox
 Apply Fibers: apply cut fiberglass mat to mold
 Apply Resin: Saturate fibers with resin
 Cure time: 24 hrs
 Demold: remove locker from mold
 Trim: cut and sand flange per drawing
 Drill holes: 4 holes drilled per drawing

Date	Initial
8/9/12	JAD
8/9/12	JAD
8/9/12	JAD
8/9/12	JAD
8/9/12	JAD
8/9/12	JAD
8/9/12	JAD
8/10/12	JAD
8/15/12	JAD
8/15/12	JAD

Stealth Composites

COMPANY NAME

3N Columbus Blvd

COMPANY ADDRESS

COMMERCIAL INVOICE

INTERNATIONAL
AIR WAYBILL NO.

8654 7028 2311

(NOTE: All shipments must be
accompanied by a Federal Express
International Air Waybill.)

DATE OF EXPORTATION

8-15-12

EXPORT REFERENCES (i.e., order no., invoice no.)

SHIPPER/EXPORTER (complete name and address)

Stealth Composites
3N Columbus Blvd
Philadelphia PA 19106

CONSIGNEE (complete name and address)

Dart Aerospace
1270 Aberdeen St
Hawkesbury ON K6A1K7

COUNTRY OF EXPORT

USA

IMPORTER — IF OTHER THAN CONSIGNEE
(complete name and address)

COUNTRY OF MANUFACTURE

USA

COUNTRY OF ULTIMATE DESTINATION

Canada

MARKS/NOS.	NO. OF PKGS.	TYPE OF PACKAGING	FULL DESCRIPTION OF GOODS	QTY.	UNIT OF MEA- SURE	WEIGHT	UNIT VALUE	TOTAL VALU
	3	box	Fiberglass Bin	1	Box		800	2400
						TOTAL WEIGHT		TOTAL INVOICE VALU
						20		77

SEE REVERSE SIDE FOR HELP WITH THE ABOVE SECTION

FOR U.S. EXPORT ONLY: THESE COMMODITIES, TECHNOLOGY, OR SOFTWARE WERE EXPORTED FROM THE
UNITED STATES IN ACCORDANCE WITH THE EXPORT ADMINISTRATION REGULATIONS. DIVERSION CONTRARY
TO UNITED STATES LAW IS PROHIBITED.

I DECLARE ALL THE INFORMATION CONTAINED IN THIS INVOICE TO BE TRUE AND CORRECT.

SIGNATURE OF SHIPPER/EXPORTER (Type name and title and sign.)

DATE

Check c

☐ F.O.B.☐ C &☐ C.I.F.

N° DE COMMANDE - ORDER NO. PO 17579		DÉP. - DEPT.		DATE 31/07/2012	
VENDU À - SOLD TO			EXPÉDIÉ À - SHIP TO STEALTH COMPOSITE		
ADRESSE - ADDRESS			ADDRESS Philadelphia PA 19106		

230924

SIGNATURE

Nº LIC. - LIC. NO

TOTAL



ACI-901822640236

Commercial Invoice

Invoice Number	Purpose of Shipment	Curr	Ult Dest.	Air Waybill Nbr.
Export Dt	Gift	USD	US	901822640236
7/31/2012	C.I. References	Pkgs	Bill T/C	Bill D/T/F
	PO17579	1	1517-9324-0	1517-9324-0
		BOX		

Shipper:
Futh Molnar
Dart Aerospace Ltd.
1270 Aberdeen St.

Consignee:
John Dice
Stealth Composites Inc.
3 North Columbus Blvd.

HAWKESBURY
ON K6A1K7 CA (613) 632-5200
ID/EIN:

PHILADELPHIA
PA 19106 US (215) 919-7584
ID/EIN:

Broker

Importer
John Dice
Stealth Composites Inc.
3 North Columbus Blvd.

PHILADELPHIA
PA 19106 US (215) 919-7584
ID/EIN:

Part Nbr:D2600-6	Marks/Nbrs:	Cntry MFG:CA	Net Wgt:	0.00 lbs
HS Code: 8803.30.	Unit Qty: 20.00 PCS	Unit Value: 3.000000	Commodity Value: 60.00	
Desc: Camlock stud				

Total Shipment Weight: 0.5

Total Commodity Value:
Terms of Sale: FCB
Freight:
Insurance:
Others:
Total Invoice Value:

Comments:

- 1)
- 2)
- 3)

I declare all information in this invoice to be true and correct.

Signature of shipper: Ruth Molnar

7/31/2012



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO17579**

Purchase Order Date 7/31/2012
PO Print Date 8/1/2012

Page Number 1 of 2

Order From :

VU-STE002

STEALTH COMPOSITES INC.
3 NORTH COLUMBUS BLVD.
PHILADELPHIA, PHILADELPHIA PA 19106
USA

Contact Name		Buyer	Linda Lacelle
Vendor Phone	215-919-7584	Requisition Nbr	
Vendor Fax	215-689-4979	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 10
		Currency	USD
		FOB	Destination-Collect

Ship To : DART AEROSPACE LTD - 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D350-604-041P	Rear Locker Extender	8/15/2012 Yes	✓ 1.00 Each	FedEx PI collect	\$475.0000	\$475.00
Special Inst: PRICING TO BE DISCUSSED BETWEEN JOHN FROM STEALTH AND ISAM FROM DART MADE WITH RADOM MAT							
2	D350-604-041P	Rear Locker Extender	8/15/2012 Yes	✓ 1.00 Each	FedEx PI collect	\$475.0000	\$475.00
3	D350-604-041P	Rear Locker Extender	8/15/2012 Yes	✓ 1.00 Each	FedEx PI collect	\$475.0000	\$475.00
4	D350-604-041P	Rear Locker Extender	8/15/2012 Yes	1.00 Each	FedEx PI collect	\$475.0000	\$475.00

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required - YES NO

Change Nbr: 2

Change Date: 8/1/2012